

split

Date: Wednesday, 03/09/2008 10:35:13 AM  
User: Julie Lecocq

Process Sheet

|   |                                |
|---|--------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services        | Drawing Name : SADDLE ASSEMBLY |
| Job Number : 41767B                                   |                                |
| Estimate Number : 11180                               |                                |
| P.O. Number :   | Part Number : D2282043         |
| This Issue : 03/09/2008 S.O. No. :                    | Drawing Number : D2282 REV E   |
| Prsht Rev. : NC                                       | Project Number : N/A           |
| First Issue : / / Type : SMALL /MED FAB               | Drawing Revision : E           |
| Previous Run : 41173B                                 | Material :                     |
| Written By :  | Due Date : 30/10/2008          |
| Checked & Approved By : <u>JUL 08.9.03</u>            | Qty: 100 Um: Each              |
| Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM |                                |

Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0 D2281 Jack Saddle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

|                 |             |               |
|-----------------|-------------|---------------|
| Qty Part Number | Description | Batch         |
| 1 D2281         | Saddle      | B 41888 → 53x |
|                 |             | B 39817 → 47x |

(48) (50)

LY 08/10/09

2.0 D22827 Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s) B 41891 → 99x

Pick:

|                 |             |               |
|-----------------|-------------|---------------|
| Qty Part Number | Description | Batch         |
| 2 D2282-7       | tube        | B 39818 → 34x |
|                 |             | B 35474 → 67x |

LY 08/10/09

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

A/R ER316L SS Filling Rod M108775  
Dwg Rev: E

LY 08/10/16

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush, take all welding marks out and deburr holes

SAD 08/10/21 100

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 41767B

Part Number: D2282043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/22

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/22 (X100)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble

B 8-11-06

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/06

(+50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Sylvie

8/10/06

(50x)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06 HJ

Job Completion



MF 08-11-06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

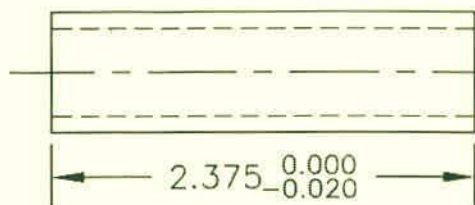
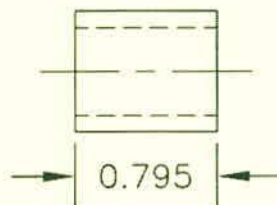
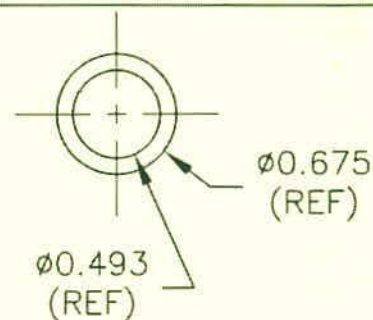


**DART**

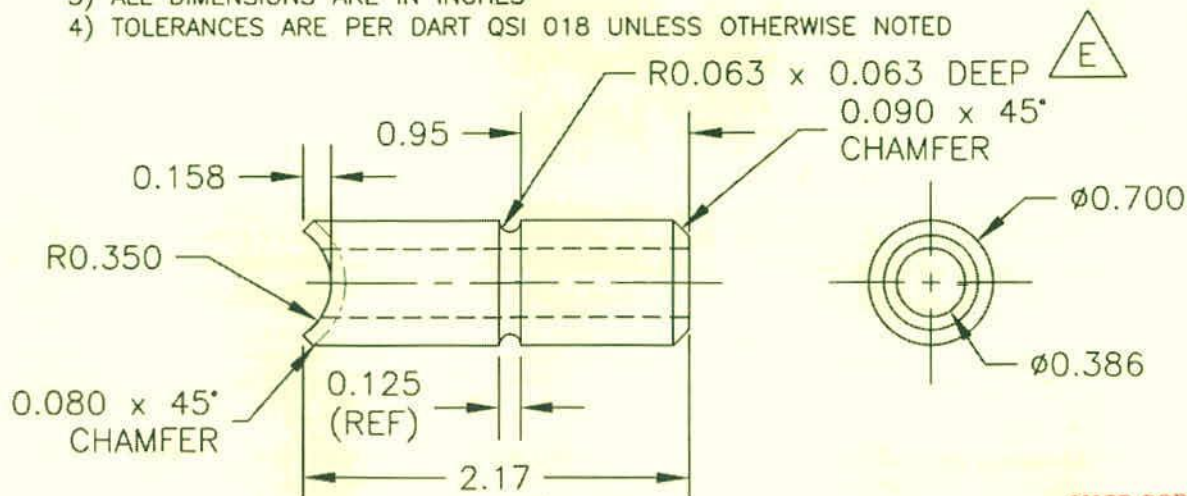
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282  | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07              | TITLE<br>HANDLE TUBES          |   | SCALE<br>1:1           |
| A                             | 94.10.14                       | NEW ISSUE   |                        |
| B                             | 95.03.23                       | RE-DESIGN   |                        |
| C                             | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                             | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                             | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

RELEASED  
*[Signature]*

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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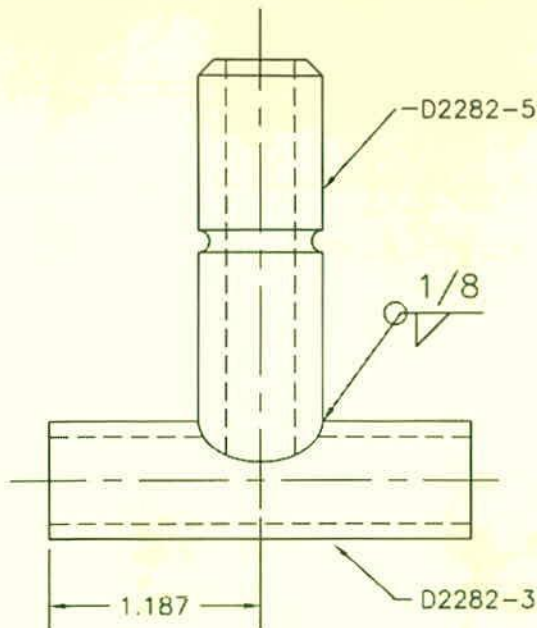
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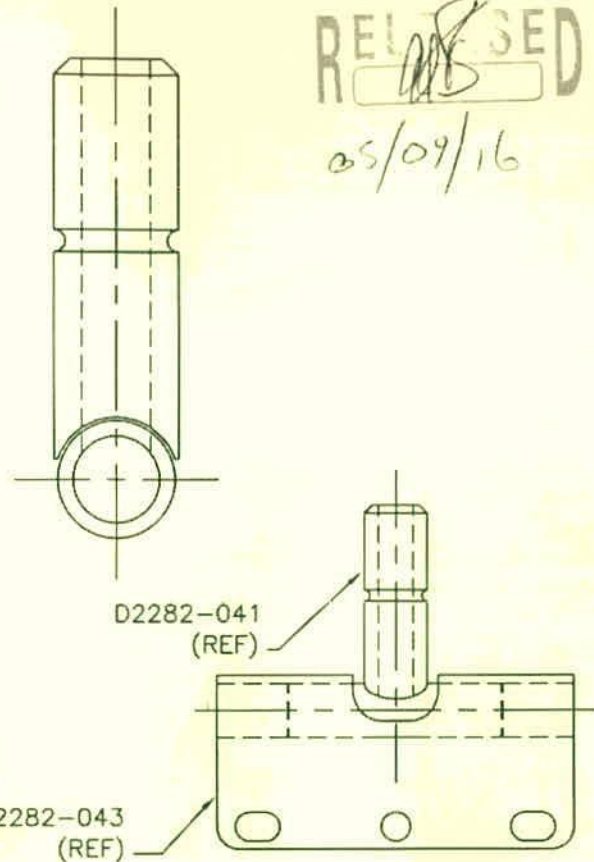


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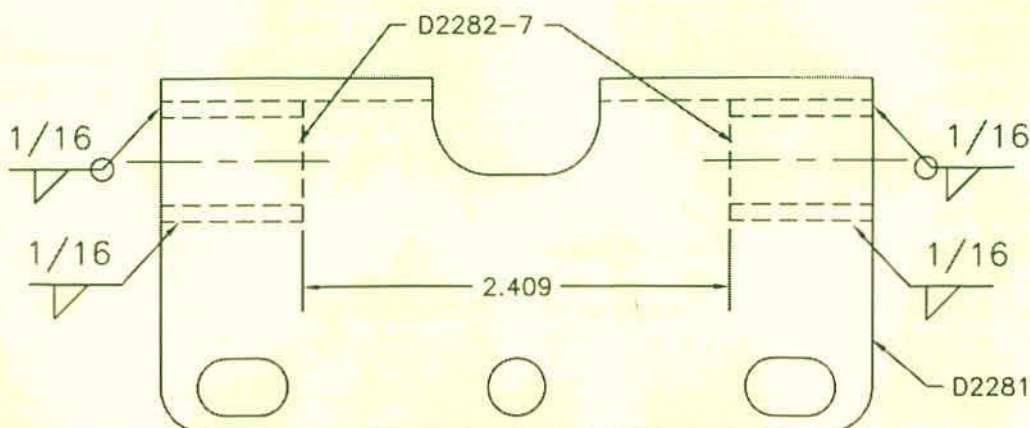
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| CHECKED<br><i>UP</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>05.06.07     |                                | TITLE<br>HANDLE TUBES                             | SCALE<br>1:1           |



**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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